



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.0112
Job Sheet 169587



Part No: 647.0112

Job Qty: 30 ea

Part Name: Strut Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/14/17

Job Tracking No:

Due Date: 1/12/18

Created By: Mario Poulin

Type: Stock

Description:

Customer: Alpine Aerotech LP - Kelowna (CALPI02)

1260 Industrial Road Kelowna, BC, V1Z 1G5 Canada ph:(250) 769-6344 fx:(250) 769-6303.

Note: DWG REV A SHEET 3 IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea		1/11/18	0.00	0.00	Start Up Waterjet		OK 17/12/16
100	Waterjet	30 pcs		1/11/18	0.00	1.18	Waterjet1		OK 17/12/16
110	QC	30 pcs		1/11/18	0.00	0.00	QC2 Waterjet-1		OK 17/12/16
120	QC	30 pcs		1/11/18	0.00	0.00	QC8-1		38
130	Brake NC	30 pcs		1/11/18	0.00	1.34	Brake NC 1		2.00 DAE
140	QC	30 pcs		1/11/18	0.00	0.00	QC5		38
150	SprayPaint	30 pcs		1/12/18	0.00	0.70	Spray Paint		9-58
160	QC	30 pcs		1/12/18	0.00	0.00	QC14		11
170	Packaging	30 pcs		1/12/18	0.00	0.00	Packaging3-1	OK 10p	MAR 2 2 2018
180	QC21-SA	30 Ea		1/12/18	0.00	0.00	QC21		21 MAR 2 3 2018

Part Op 100 - 1-Cut as per Dwg

Descriptions: 130 - USE DT9834 FOR FORMING

150 - PRIME AS PER DWG NOTE 6 BATCH: 138747

170 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S14GA	1	82	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut Bracket	0.177Inches	+ 0.005 - 0.001	0.182 0.176	
2	Strut Bracket	0.191Inches	+ 0.005 - 0.001	0.196 0.190	
3	Strut Bracket	0.300Inches	± 0.030	0.330 0.270	
4	Strut Bracket	0.900Inches	± 0.030	0.930 0.870	
5	Strut Bracket	0.350Inches	± 0.010	0.360 0.340	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com					
Description Work Order Deviation									
Root Cause <table style="width: 100%;"> <tr> <td style="width: 50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width: 50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width: 100%;"> <tr> <td style="width: 50%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width: 50%;"> Ter ☐ Set- ☐ BO ☐ Bro ☐ Insp ☐ Con ☐ Cou ☐ Cut ☐ Inst ☐ Drill Holes ☐ </td> </tr> </table>		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Ter ☐ Set- ☐ BO ☐ Bro ☐ Insp ☐ Con ☐ Cou ☐ Cut ☐ Inst ☐ Drill Holes ☐	 S023582 Strut Bracket	
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OTHER : _____		647.0112 Start up Operation Mfg Date: 12/16/17 Job No: 169587 PART NO: Revision: Operation: Change No: QC / QA Coordinator Approval Completed By RB (QSI042) Approval Engineering Quality Other							

6	Strut Bracket	1.500Inches ± 0.030	1.530 1.470
7	Strut Bracket	1.006Inches ± 0.030	1.036 0.976
8	Strut Bracket	0.080Inches ± 0.010	0.090 0.070

Plex 12/14/17 8:59 AM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

DART AEROSPACE LTD	Work Order:	169587
Description: Strut Bracket	Part Number:	647.0112
Inspection Dwg: 647.0100 Rev: A		Page 1 of 1

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